

Date: Friday, 11/18/2005 3:18:16 PM  
 User: Linda Lacelle

## Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 24839 -			Part Number	: D2573	
Estimate Number	: 10533			Drawing Number	: D2573 REV D	
P.O. Number	: N/A			Project Number	: N/A	
This Issue	: 11/18/2005 S.O. No. : N/A			Drawing Revision	: D	
Prsht Rev.	: NC			Material	: N/A	
First Issue	: N/A			Due Date	: 12/20/2005	
Previous Run	: 24434			Qty:	(12) Um: Each	
Written By	: See comment below					
Checked & Approved By	: See comment below					
Comment	: Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: B24893	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: B24893 Double check by: <u>EN</u> 06/01/09	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	<u>- J. G</u> <u>- M8</u> 06/01/09
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	 <u>J. G</u> <u>M8</u> 06/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/01/18  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section-A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number: 24839		Part Number: D2573
Job Number:		
Seq. #:	Machine Or Operation:	Description :
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		5. G 06/01/14 8
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		Ep 06/01/14 8
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		SAD 06/01/14 8
7.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		M 06/01/16 8
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT		Co 06/1/17 8
9.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 377		Po 06/1/17 8
10.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Inspection Level 21		545 06/01/18 8
Job Completion		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyNov 17, 2005  
03:30 pm

Work Order No : 0024839  
 Project Name : D2573 Department Code:  
 Project For : WK550 Burden Flags : NNNNNNN  
 Work Order Type : Main WO Status : Open  
 Main WO Number : Invoice State : Not Invoiced  
 House Part Number : D2573 Invoice Date :  
 Description : Saddle, Aft, Out Invoice Number :  
 Manufactured : Yes Invoice Amount : 0.00  
 Amount Req'd : 12 Order Entry No :  
 Amount Done : 0 OE Value : 0.00  
 Start Date : 11-17-05  
 Est Finish Date : 12-20-05  
 Act Finish Date :  
 Drawings Reqd : No Est Margin : 0.000%  
 Ok for Approval : Actual Margin : 0.000%  
 Approval Rec'd :  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00	0.00	0.00
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00	0.00	0.00
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00	0.00	0.00
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00	0.00	0.00
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00	0.00	0.00
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00	0.00	0.00
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00	0.00	0.00
Total Cost	0.00	0.00	0.00	0.00	0.00
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD

Work Order:

Description: Saddle, Aft Outboard

Part Number:

D2573

Inspection Dwg: D2573 Rev. E

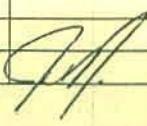
Page 1 of 1

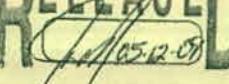
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	✓	✓	✓	✓	
B	1.745	1.755		1.746	1.751	1.752	1.751		
C	3.495	3.505		3.495	3.502	3.501	3.501		
D	1.745	1.755		1.746	1.750	1.752	1.751		
E	7.990	8.010		8.002	8.003	8.008	8.003		
F	0.490	0.510		0.500	0.507	0.503	0.508		
G	0.257	0.262	DT8683	0.257	✓	✓	✓	✓	
H	0.375	0.380	DT8684	0.376	✓	✓	✓	✓	
I	0.490	0.510		0.498	0.507	0.503	0.508		
J	1.174	1.184		1.179	1.178	1.180	1.180		
K	0.558	0.578		0.564	0.578	0.565	0.566		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.371	1.370	1.370	1.370		
N	2.495	2.505		2.501	2.500	2.500	2.500		
O	4.119	4.129		4.127	4.125	4.121	4.122		
P	0.115	0.135		.131	.130	.126	.127		
Q	0.115	0.135		0.120	.128	.133	.135		
R	0.240	0.260		.255	.255	.248	.252		
S	0.115	0.135		.134	.135	.128	.124		
T	0.178	0.198		0.187.5	.188	.188	.188		
U	3.210	3.250		3.233	3.233	3.232	3.233		
V	0.230	0.250		0.247	.246	.242	.242		
W	0.115	0.135		0.116	.135	.133	.130		
X	0.308	0.313		0.308	0.308	0.308	0.308		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.365	.368	.362	.362		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.635	.631	.633	.635		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		.256	.260	.258	.249		
AE	1.500	1.520		1.506	1.506	1.508	1.511		
AF	0.115	0.135		0.118	.128	.125	.130		
AG	0.240	0.280		0.255	.270	.270	.255		
AH	0.240	0.260		0.257	.256	.255	.255		
AI	2.000	2.020		2.000					
AJ	0.023	0.043							

Accept/Reject

Measured by: J. G  
Date: 06/01/05Audited by: SP  
Date: 06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED  
 05/12/05



DART AEROSPACE LTD

Work Order:

Description: Saddle, Aft Outboard

Part Number:

D2573

Inspection Dwg: D2573 Rev. E

Page 1 of 1

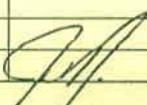
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

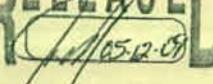
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.748	1.748	1.748	1.747		
C	3.495	3.505		3.499	3.497	3.497	3.498		
D	1.745	1.755		1.748	1.747	1.748	1.747		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		0.504	0.505	0.503	0.504		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.502	0.500	0.499	0.501		
J	1.174	1.184		1.177	1.178	1.178	1.176		
K	0.558	0.578		0.569	0.568	0.567	0.565		
L	1.174	1.184		1.178	1.177	1.178	1.177		
M	1.365	1.375		1.368	1.368	1.368	1.367		
N	2.495	2.505		2.495	2.496	2.497	2.498		
O	4.119	4.129		4.119	4.120	4.121	4.121		
P	0.115	0.135		0.123	0.124	0.123	0.123		
Q	0.115	0.135		0.135	0.134	0.135	0.133		
R	0.240	0.260		0.249	0.248	0.247	0.247		
S	0.115	0.135		0.122	0.122	0.120	0.123		
T	0.178	0.198		0.190	0.190	0.190	0.190		
U	3.210	3.250		3.230	3.230	3.231	3.231		
V	0.230	0.250		0.239	0.240	0.238	0.238		
W	0.115	0.135		0.127	0.126	0.127	0.123		
X	0.308	0.313		0.308	0.308	0.308	0.308		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.365	0.364	0.363	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.634	0.635	0.635	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.252	0.251	0.253		
AE	1.500	1.520		1.510	1.509	1.516	1.512		
AF	0.115	0.135		0.127	0.130	0.129	0.130		
AG	0.240	0.280		0.265	0.264	0.262	0.261		
AH	0.240	0.260		0.251	0.249	0.249	0.247		
AI	2.000	2.020		2.001	2.001	2.000	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: S.G  
 Date:

Audited by: Eo  
 Date: 66/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED  
  
 05.12.05

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DART AEROSPACE LTD

Work Order:

Description: Saddle, Aft Outboard

Part Number:

D2573

Inspection Dwg: D2573 Rev. E

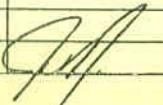
Page 1 of 1

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C	3.495	3.505		3.500	3.500	3.500			
D	1.745	1.755		1.751	1.751	1.750			
E	7.990	8.010		7.990	8.002	8.002			
F	0.490	0.510		.510	.510	.503			
G	0.257	0.262	DT8683	✓	✓	✓			
H	0.375	0.380	DT8684	✓	✓	✓			
I	0.490	0.510		.506	.503	.500			
J	1.174	1.184		1.180	1.180	1.180			
K	0.558	0.578		.573	.569	.570			
L	1.174	1.184		1.180	1.180	1.180			
M	1.365	1.375		1.371	1.371	1.371			
N	2.495	2.505		2.500	2.500	2.500			
O	4.119	4.129		4.123	4.123	4.123			
P	0.115	0.135		.122	.125	.124			
Q	0.115	0.135		.135	.135	.135			
R	0.240	0.260		.245	.249	.244			
S	0.115	0.135		.126	.124	.126			
T	0.178	0.198		.185	.188	.189			
U	3.210	3.250		3.232	3.232	3.230			
V	0.230	0.250		.237	.240	.236			
W	0.115	0.135		.125	.125	.125			
X	0.308	0.313		.312	.312	.312			
Y	0.760	0.765		.762	.762	.762			
Z	0.352	0.372		.362	.367	.368			
AA	0.470	0.530		.500	.500	.500			
AB	0.615	0.635		.633	.629	.629			
AC	0.053	0.073		.063	.063	.063			
AD	0.240	0.260		.249	.252	.249			
AE	1.500	1.520		1.512	1.512	1.510			
AF	0.115	0.135		.133	.120	.135			
AG	0.240	0.280		.260	.258	.255			
AH	0.240	0.260		.249	.248	.243			
AI	2.000	2.020		2.008	2.010	2.010			
AJ	0.023	0.043		.03	.03	.03			
Accept/Reject									

Measured by: MS  
 Date: 06/01/13

Audited by: EP  
 Date: 06/01/14

Rev	Date	Change	Revised by	Approved
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RELEASED  
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